

Work Order ID 86450

86450

Page 1

Friday, June 29, 2012 10:52:39 AM

Item ID: D4422-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 6/29/2012 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 5.00 *5*

Customer:

Reference: ALODINE *Rework*

Approvals: Process Plan: *mmf* Date: *12-06-29* Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4422

A

140	Chemical Conversion Coat per QSI005 4.1	0.00
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140

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK D4422-1 X 5 80924 AND ALODINE

5 NG 12-7-3

150	QC7-Inspect Chemical Conversion Coat	0.00
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150

QC

Memo

0.00

Quality Control

8/17/12/14

58

160	Identify as per dwg & Stock Location <i>5111</i>	0.00
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160

Packaging

Memo

0.00

Packaging

5x

80 12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 6/29/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 5.00

5

Customer:

Reference: ALODINE

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/7/4

16-074

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 86450

Parent Item: D4422-1

Parent Item Name: Shim

Start Date: 6/29/2012

Required Date: 7/3/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4422-1 Shim		Manufactured	No				Each	10.0000		5			

Location

Loc Qty

Loc Code

ST139d

10

86448

10

5X 80924 MF 12-06-29

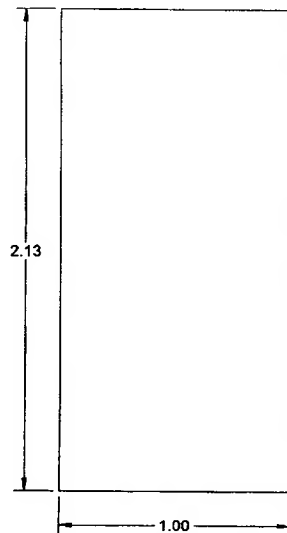
Dart Aerospace Ltd

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NOTE: Date & initial all entries



D4422-X SHIM



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125

OR

6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

RELEASED
2011-07-06

A		NEW ISSUE		MB		11.06.22	
REV.		DESCRIPTION		BY		DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 1	
DRAWN							
CHECKED		DRAWING NO.		REV. A			
MFG. APPR.		D4422					
APPROVED		TITLE		SCALE			
DE APPR.		SHIM		NTS			
DATE		11.06.22		<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
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